

4998



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

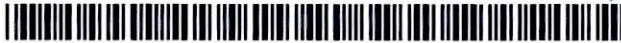
RB T101577-1-9
Job Sheet 179146



Part No: RB T101577-1-9

Job Qty: 3 ea

Part Name: Retainer



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/14/18

Job Tracking No:

Due Date: 6/15/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB T101577-1 Rev. 0 IPP Rev. A 18.05.01 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 3 Ea		6/15/18	0.00	0.00	Start Up Machining-2		
110	Mori Seiki	2 3 pcs		6/15/18	0.00	1.50	MORI SL2500Y		
120	QC	2 3 pcs		6/15/18	0.00	0.00	QC2 Machining-4		
121	Mill Conv	2 3 pcs		6/15/18	0.00	3.00	Mill Conv 1		
122	QC	2 3 pcs		6/15/18	0.00	0.00	QC2 Machining-5		
130	QC	2 3 pcs		6/15/18	0.00	0.00	QC8 Machining-4		
140	Packaging	2 3 pcs		6/15/18	0.00	0.00	Packaging3-1		
150	QC21-SA	2 3 Ea		6/15/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per folio FC141 FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 121 - 1-Machine as per DWG. 2-Debur

130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

DAG
21
2-00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R2.500	Bronze C63000 Round Bar 2.500"	1.905 ft (.0635 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R2.500	0	2	0

Part Specifications

Specifications could not be found.



Container No: S083859



Part: RB T101577-1-9

Job No: 179146

Serial No/Batch: S083569

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

8 10:14 AM dart.logan.david

Date: 06/26/18

4998

SHIP
6-15

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T101577-1-9
Job Sheet 177101



Part No: RB T101577-1-9

Job Qty: 1 ea

Part Name: Retainer



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/7/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T101577-1 Rev. 0 IPP Rev. A 18.05.01 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/15/18	0.00	0.00	Start Up Machining-2		
110	Mori Seiki	1 pcs		6/15/18	0.00	0.50	MORI SL2500Y		
120	QC	1 pcs		6/15/18	0.00	0.00	QC2 Machining-4		
130	QC	1 pcs		6/15/18	0.00	0.00	QC8 Machining-4		
140	Packaging	1 pcs		6/15/18	0.00	0.00	Packaging3-1		
150	QC21-SA	1 Ea		6/15/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per folio FC 141 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 120 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R2.500	Bronze C63000 Round Bar 2.500"	.0635 ft (.0635 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R2.500	0	2	0

Part Specifications

Specifications could not be found.

Plex 6/13/18 3:31 PM dart.logan.david

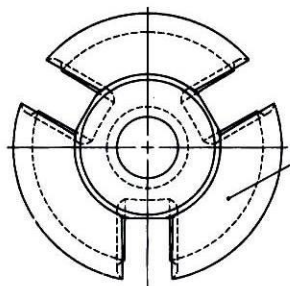
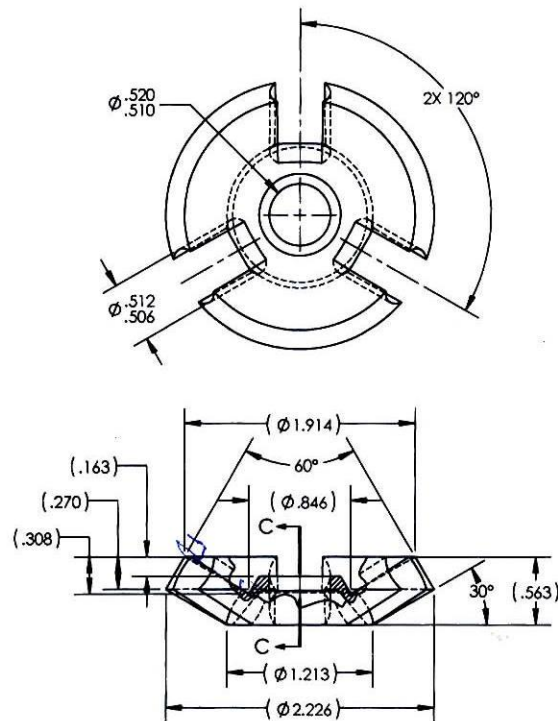
Gullon @ 3:30pm

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REV		DESCRIPTION	DATE	INITIAL	APPROVED
REVISIONS					

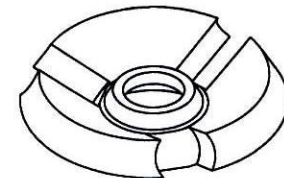
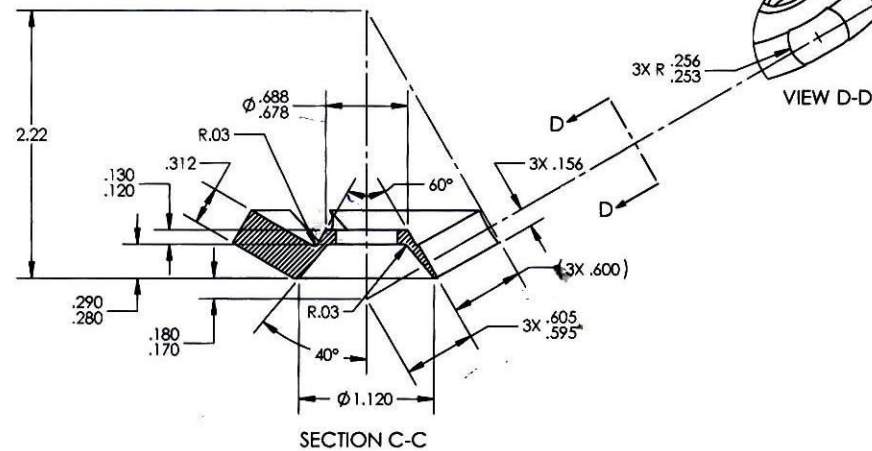
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 177101
20180613
72



ENGRAVE: "RB T101577-1-9"

RETAINER



RED BARN MACHINE	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-9	
MAY 1 ALUM. BRONZE UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .010 XX ± .03 X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: SMITH APPROVED: <i>D. Wall</i> TEST: _____ FINISH: _____ SPEC: _____ USED ON MODEL: _____
SCALE 1:1	DATE 8/26/2013

SHEET 5 OF 10

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

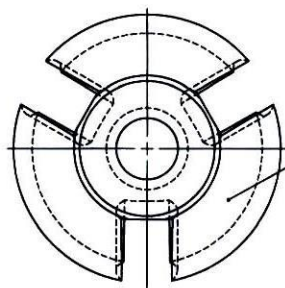
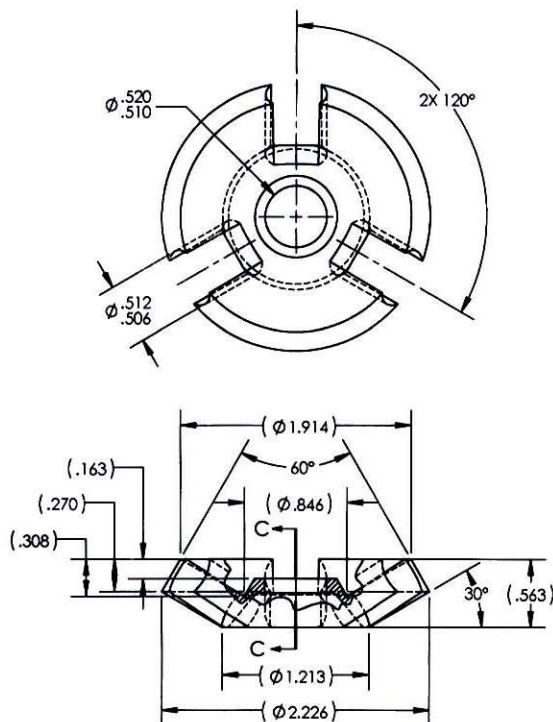
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
				Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

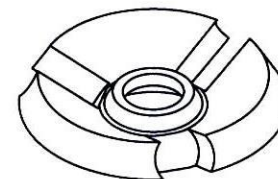
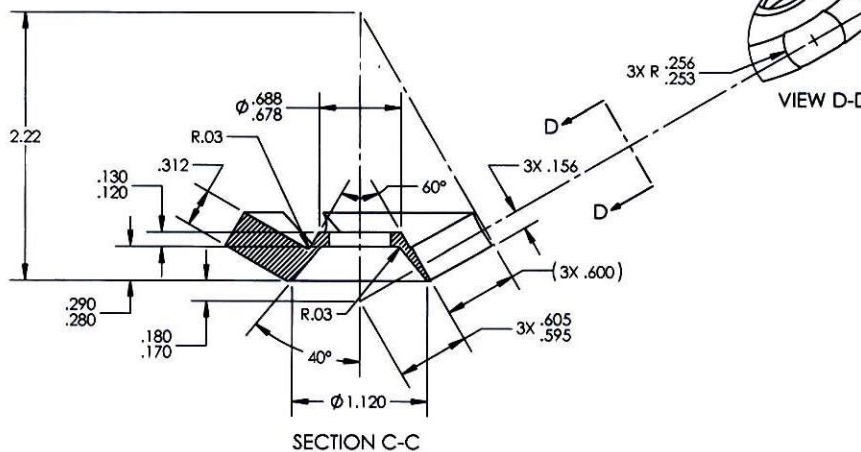
AOG (7854) New slo to add.

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



ENGRAVE: "RB T101577-1-9"



⑨
RETAINER

RED BARN MACHINE	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWD NO. RB T101577-1-9	
MAT'L: ALUM. BRONZE	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED	APPROVED: <i>D. Wall</i>
DIMENSIONS ARE IN INCHES	TEST: <i>D. Wall</i>
.XXX ± .010	FRACTIONS ± 1/32
.XX ± .005	ANGLES ± .5°
.X ± .1	FRESH
1. BREAK ALL SHARP EDGES .015 x 45°	SPEC
OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE: 1:1	DATE: 8/28/2013
SHEET 5 OF 10	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Job Operations

Job No: **179146-A**
Part No: **RB T101577-1-9** Job Qty: **1 ea**
Material:

Op No	Operation	Op Qty	Start Date	Due Date	Center	Standard		Schedule		Actual					Inv	Job Op Note
						Setup hrs	Run Hrs	Start Date	hrs	Status	Start Date	Completion Date	Setup hrs	Run Hrs		
120	QC	1		6/22/18		0.00	0.00			Completed	6/25/18 1:16 PM	6/25/18 1:16 PM	0.00	0.00		
121	Mill Conv	1		6/22/18	Mill Conv 1	0.00	1.00	6/21/18 11:00 PM	1.00	Completed	6/25/18 2:40 PM	6/25/18 2:46 PM	0.00	1.00		
122	QC	1		6/22/18	QC2 Machining-5	0.00	0.00	6/22/18 12:00 AM	0.00	Completed	6/25/18 2:44 PM	6/25/18 2:46 PM	0.00	0.02		
130	QC	1		6/22/18	QC8 Machining-4	0.00	0.00	6/22/18 12:00 AM	0.00	Completed	6/25/18 3:11 PM	6/25/18 3:13 PM	0.00	0.03		
140	Packaging	1		6/22/18	Packaging3-1	0.00	0.00	6/22/18 12:00 AM	0.00	Completed	6/25/18 3:31 PM	6/25/18 3:32 PM	0.00	0.01		
150	QC21-SA	1		6/22/18	QC21	0.00	0.00	6/22/18 12:00 AM	0.00	Completed	6/25/18 3:36 PM	6/25/18 3:37 PM	0.00	0.01	1	